

# ACCUMULATING CONVEYOR SYSTEM

## Abstract

An accumulation conveyor system and method of accumulating articles includes providing an accumulation assembly that is adapted to accumulating a plurality of articles into a slug of articles. Slugs of articles are discharged to a transport line which transports the slugs and accumulates the slugs as required. The accumulation assembly is made up of a slug forming section which forms slug portions and discharges slug portions into slugs. The accumulation assembly accumulates articles in zones and reduces gaps between articles in sequence from upstream gaps to downstream gaps.